

Work Order ID 51331

August 19, 2009 11:13:31 AM



Page 1

Item ID:	D2327-1	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Spacer Bushing					
Start Date:	08/19/2009	Start Qty:	20.00		Cust Item ID:	
Required Date:	08/26/2009	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09-08-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2327	Rev D								

100		Hardinge CNC LATHE SMALL	0.00	<u>SA 09/08/25</u>	<u>20</u>	<u>Ø</u>		
	Hardinge	Memo	0.00					
	Hardinge CNC Lathe Small		Turn per Folio FA232 and Dwg D2327 <input type="checkbox"/> Debur					

110		QC2- Inspect parts off machine FAI/FAIB	0.00	<u>SA 09/08/25</u>	<u>20</u>	<u>Ø</u>		
	QC	Memo	0.00					
	Quality Control							

120		QC8- Inspect parts - second check	0.00	<u>amk 09/08/25</u>	<u>20</u>	<u>Ø</u>		
	QC	Memo	0.00					
	Quality Control							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

August 19, 2009 11:13:31 AM

Accept

Setup Start

Abstract

Stop

[illegible]**Cust Item ID:**

Start Date: 08/19/2009 **Start Qty:** 20.00

Required Date: 08/26/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start

RESEARCH

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

Accept	Qty
--------	-----

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: Basket

0.00

1. The first step is to identify the problem. This involves understanding the current situation and what needs to be changed.

2. The second step is to set goals. These should be specific, measurable, achievable, relevant, and time-bound.

3. The third step is to develop a plan. This involves determining the steps that need to be taken to achieve the goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making any necessary adjustments.

5. The fifth step is to evaluate the results. This involves assessing the progress made and determining if the goals have been achieved.

Packaging

Memo

0.00

Packaging

1D 09.08-25 (25)

140

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Memo

0.00

Quality Control

09/08/26 HJ

NO 098-25

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Picklist Print

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Work Order ID: 51331

Parent Item: D2327-1RevD

Parent Item Name: Spacer Bushing



Comments:

Start Date: 08/19/2009

Required Date: 08/26/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375 		Purchased	No			100	f	10.7932	3.7284 			
304 ROUND BAR 0.375												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	10.79317895	
110166	3.32	
110472	6.41	
112058	1.06317895	

M112473 07.08.21
M112473 08/25

3.5 ft

W/O:		WORK ORDER CHANGES					
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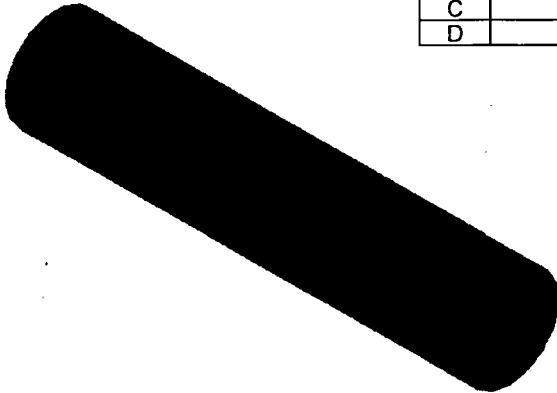
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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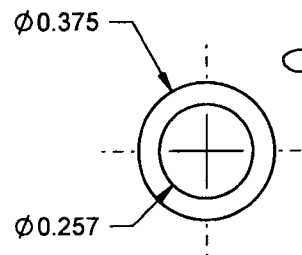
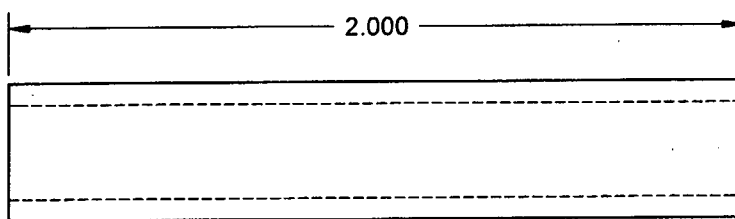
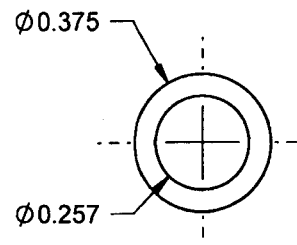
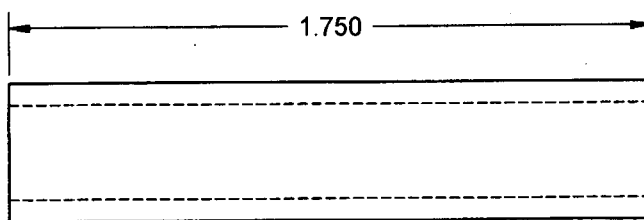
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HT	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

**RELEASED**

06.11.14

#51331
SME
05-08-19**D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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